

Date: Tuesday, 11/21/2006 11:31:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 29566		
Estimate Number	: 11162		
P.O. Number	: N/A	Part Number	: D32641
This Issue	: 11/21/2006 S.O. No. : N/A	Drawing Number	: D3264 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 12/5/2006 Qty: 8 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est A04.09.02 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
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Comment: Qty.: 0.5097 f(s)/Unit Total: 4.0774 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
 (M6061T6B1.250x04.500)
 Identify for D3264-1
 Batch: M17655

J.L 06/12/01 (9)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 4.500" x 1.250" x 5.700" long Bar

J.L 06/12/01 (9)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA447 and Dwg D3264
 Identify as D3264-1
 Deburr

J.F. 06/12/03 (9)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/03 (9)

5.0	QC8	SECOND CHECK
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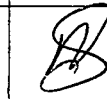
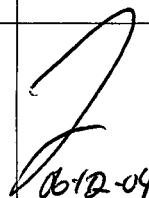
Comment: SECOND CHECK

J.G 06/12/04 9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/12/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-11-04	3.0	1 part the holes are off by .020". Instead of .600, is .580". 1st part, and origin was off by .020" operator error.		PART ACCEPTABLE.	 06/12/05	 06-12-04	 06-12-04	 06-12-04

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:31:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29566

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Y Lam 06/12/05 x 9

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Y Lam 06/12/06 x 9

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/12/06 9

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *57104*

06/12/06 9

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/08 (9)
W 06/12/08

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29566
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.690"	✓			
0.063	+/-0.010	.062"	✓			
0.125	+/-0.010	.116"	✓			
0.875	+/-0.010	.873"	✓			
0.062	+/-0.010	.061"	✓			
R0.03	+/-0.030	R0.03"	✓			
R0.13	+/-0.030	R0.13"	✓			
1.00	+/-0.030	1.000"	✓			
0.125	+/-0.010	.126"	✓			
0.600	+/-0.010	.500	✓			
4.000	+/-0.005	4.005"	✓			
0.750	+/-0.010	.749"	✓			
Ø0.194	+0.005/-0.000	Ø.199"	✓			
5.50	+/-0.030	5.504	✓			
0.125	+/-0.010	.127"	✓			
0.063	+/-0.010	.066"	✓			
R0.25	+/-0.030	R0.25"	✓			
4.27	+/-0.030	4.273"	✓			
R0.30	+/-0.030	R0.030"	✓			

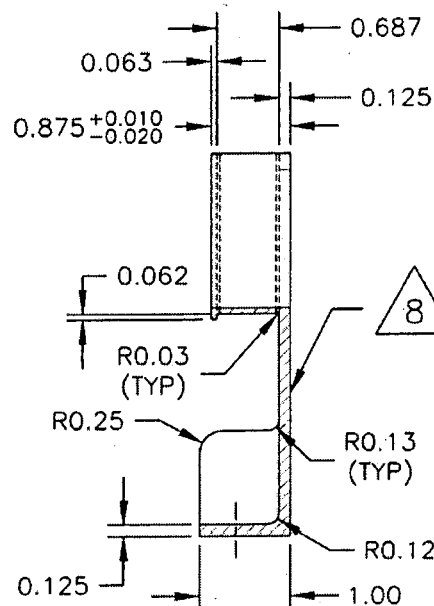
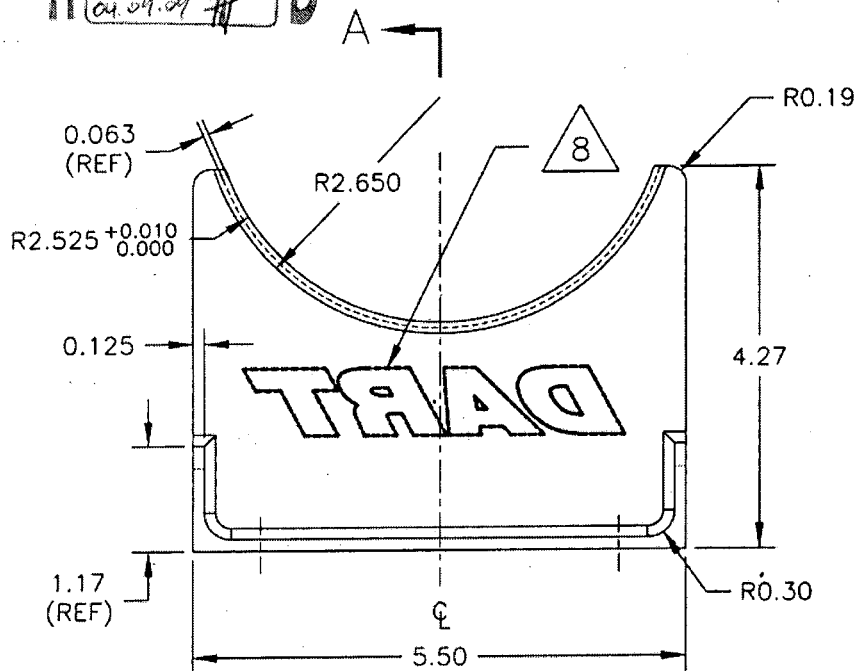
Measured by: J.F.	Audited by: J.G.	Prototype Approval:	N/A
Date: 06/12/02	Date: 06/12/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	

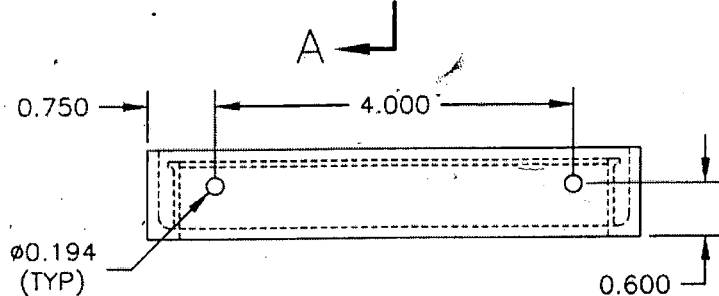


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.09



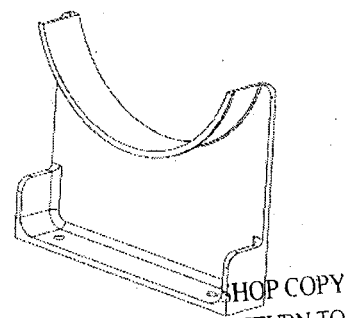
SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M0061T651)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3:5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29566

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